

Work Order ID 62338

Monday, September 27, 2010 11:31:36 AM

Page 1

Item ID: D3610-041

Accept

Revision ID:

Item Name: Bracket

Start Date: 9/27/2010 Start Qty: 8.00

Required Date: 10/4/2010 Req'd Qty: 8.00

Reference:

Approvals:

Process Plan:

Date: 10-9-27

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3610

Rev A

100

0.00



Bandsaw

BAND SAW

Memo

0.00

Jeaspa Bandsaw

Cut blank 6.600 " long

16 0 10/11/04

110

0.00



HAAS 1

HAAS CNC VERTICAL MACHINING #1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA692 Rev: & Dwg D3610 Rev: □2-Deburr per dwg D3610

16 0 10/11/22

120

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

16 0 10/11/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3610-041 PAR #: _____ Fault Category: machining NCR: (Yes) No DQA: / Date: 10-12-02
 Resolution: Accepted Disposition: use as is QA: N/C Closed: / Date: 10/12/02

NCR: <u>62338</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>0.11.23</u>	<u>110</u>	<u>QTY.(1) IS 0.005" TOO DEEP (0.125" ± 0.010"). ACTUAL IS 0.140". P.C. SETUP ON PART.</u>	<u>10.11.23</u>	<u>ACCEPTABLE ON THE BAY, THAT THE STRESS IS LOCATED IN THE AREA OF Ø0.277" HOLE CLOSE TO BEND.</u>	<u>B.A 10/11/23</u>	<u>10/11/23</u>	<u>10.11.23</u>	<u>10/11-24</u>

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62338

Monday, September 27, 2010 11:31:36 AM

Page 4

Item ID: D3610-041

Accept

Revision ID:

Item Name: Bracket

Start Date: 9/27/2010 Start Qty: 8.00

Required Date: 10/4/2010 Req'd Qty: 8.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

200

Identify as per dwg & Stock Location: 244A

0.00



Packaging

Memo

0.00

Packaging

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

X1610/11/30 16010/12/02MF10-11-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, September 27, 2010 11:31:40 AM

Page 1

Work Order ID: 62338

Parent Item: D3610-041

Parent Item Name: Bracket



Start Date: 9/27/2010

Required Date: 10/4/2010

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP rev A new issue 07.03.28 EC
IPP rev B released, changed mat'l EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M4140N- B1.500X1.5000		Purchased	No			100	f	12.0000	0.5775	4.62			
--------------------------	--	-----------	----	--	--	-----	---	---------	--------	------	--	--	--



4140 Steel Bar 1.50 x 1.50

Location	Loc Qty	Loc Code
----------	---------	----------

MAT	12	
112397	12	

MS20426AD3-4		Purchased	No			110	Each	6,388.000	2	16			
--------------	--	-----------	----	--	--	-----	------	-----------	---	----	--	--	--



RIVET

Location	Loc Qty	Loc Code
----------	---------	----------

ST316	6388	
104374	2388	
110398	4000	

MS21075L3		Purchased	No			180	Each	50.0000	1	8			
-----------	--	-----------	----	--	--	-----	------	---------	---	---	--	--	--



Nutplate

Location	Loc Qty	Loc Code
----------	---------	----------

ST303	50	
113734	1	
114760	49	



10/11/10

M115869 9.24

9/30/11/30

32

9/30/11/30

M115908 (168)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 62338
Description: <u>BRACKET PLATE</u>		Part Number: <u>D3610-04</u>
Inspection Dwg: <u>D3610</u> Rev: <u>A</u>		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.25	+/- .030	1.250	✓		Vern	Vern GA-01
0.250	+/- .010	0.250	✓		"	"
0.63	+/- .030	0.624	✓		"	"
6.50	+/- .030	6.501	✓		Vern	CNC - 02
3.00	+/- .030	3.000	✓		Vern	GA-01
2.677	+/- .010	2.677	✓		"	"
0.38	+/- .030	0.372	✓		"	"
R 0.13	+/- .030	R0.125	✓		R-6	ref.
Ø 0.277	+0.006/-0.001	Ø 0.278	✓		Vern	GA-01
Ø 0.201	+0.005/-0.001	Ø 0.203	✓		"	"
Ø 0.098	+0.004/-0.001	Ø 0.099	✓		"	"
3.64	+/- .030	3.640	✓		"	"
0.13	+/- .030	0.125	✓		R-6	ref.
0.250	+/- .010	0.256	✓		Vern	GA-01
135°	+/- 1/2°	135°	✓		ANGLE PROTRACTOR	ML-CBB
R0.38	+/- .030	R0.375	✓		R-6	ref
R 0.63	+/- .030	R0.625	✓		"	"
1.82	+/- .030	1.820	✓		Vern	GA-01
0.94 x 0.50	+/- .030	0.938 x 0.500	✓		"	"
0.125	+/- .010	0.126	✓		"	"
0.88	+/- .030	0.889	✓		H-6	31006

Measured by: <u>B.A</u>	Audited by: <u>SA</u>	Preliminary Approval:
Date: <u>10/11/23</u>	Date: <u>10/11/24</u>	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	<u>P/O D3610-04</u>	KJ

10.04.15

SHOP COPY
RETURN TO

UNCLAS
SUBJ

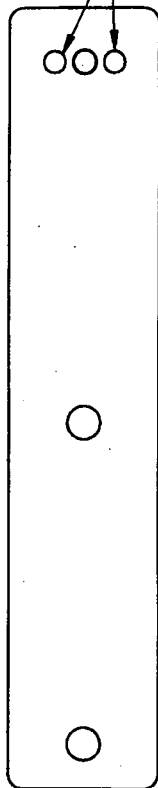
DART

WITHOUT NOTICE
WORK ORDER

NO. *62335*

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3610	REV. A SHEET 1 OF 1
DATE 07.04.20	TITLE BRACKET		SCALE 2:3
REV A	DATE 07.04.20	DESCRIPTION NEW ISSUE	

MS20426AD3-4
RIVET



MS21075L3
NUTPLATE

D3610-1
PLATE

D3610-041 BRACKET

QTY	P/N	DESCRIPTION
X	BRACKET	D3610-041
1	D3610-1	PLATE
1	MS21075L3	NUTPLATE
2	MS20426AD3-4	RIVET

D3610-041 NOTES:

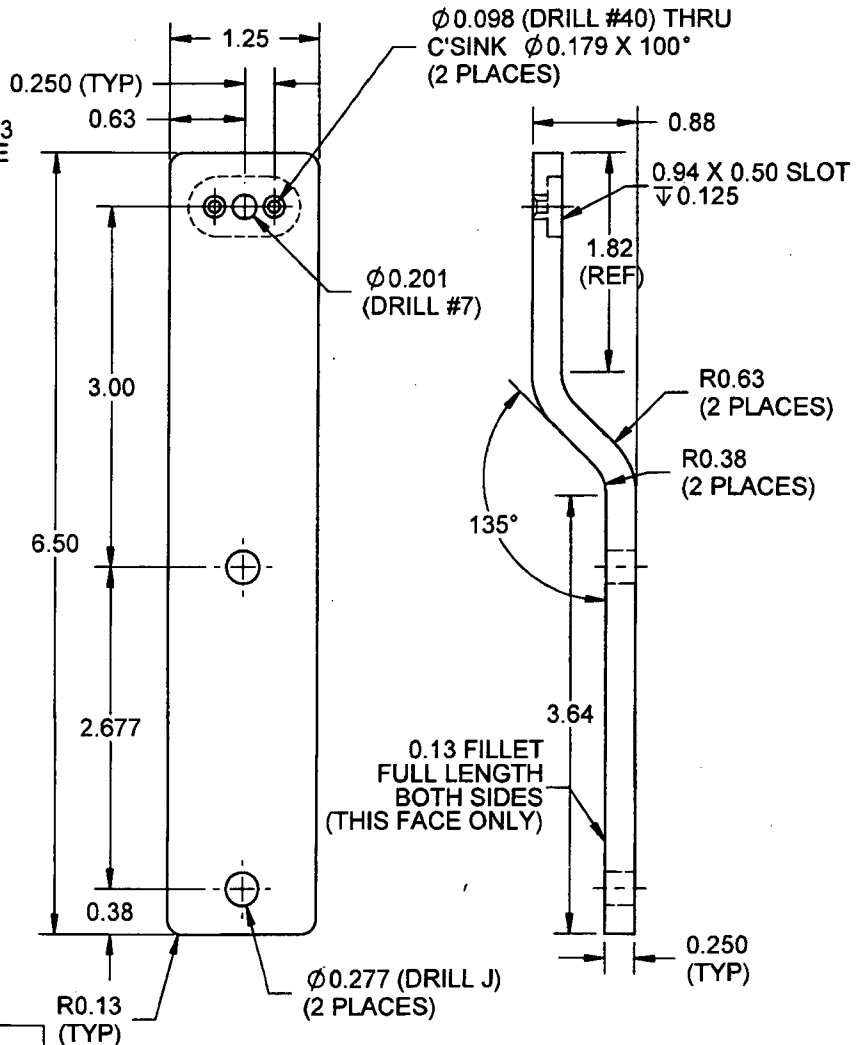
1) IDENTIFY WITH DART P/N "D3610-041" USING FINE POINT PERMANENT INK MARKER

D3610-1 NOTES:

- 1) MATERIAL: 4130N STEEL BAR PER MIL-S-6758 OR AMS 6348 OR 6370 OR 6528 (REF DART SPEC M4130N-B) OR 4140N STEEL BAR PER MIL-S-5626 OR AMS 6382 OR 6349 OR 6529 (REF DART SPEC M4140N-B)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

COPYRIGHT © 2007 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



D3610-1 PLATE

RELEASED

07.04.25 *[Signature]*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries